

Work Order ID 109042

109042

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November-07-13 7:12:13 AM

Item ID: D2940-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Support

Start Date: 11/07/13 Start Qty: 20.00 *20* Cust Item ID:

Required Date: 12/19/13 Req'd Qty: 20.00 *20* Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-11-07 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2940	C
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100

100

HAAS

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per Folio FA079

2-Deburr

0.00

0.00

D.P./D.P.

DAS
02
2-89

13-11-11

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

D.P./D.P.

DAS
02
2-89

13-11-11

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

OK 13/11/20

20

Work Order ID 109042

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Item ID: D2940-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support
 Start Date: 11/07/13 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 12/19/13 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

13-12-16
MF
13-12-16

Picklist Print

November-07-13 7:12:16 AM

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Work Order ID: 109042

109042

Parent Item: D2940-1

D2940-1

Parent Item Name: Support

Start Date: 11/07/13

Required Date: 12/19/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C 02.11.26Reformat; Added P/OKJ
IPP Rev:D Added priming as per Rev B 07-04-30 JLM
IPP E 08.03.19 Re-format Ec verified by DD
IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G
11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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DSK081		Manufactured	No			110	Each	11.0000	0.5	11			
DSK081									**				
D2940-1 Turning Detail													

Location

Loc Qty

Loc Code

MAT060

11

101402

1

104459

10

10

DR
13/11/08.

DART AEROSPACE LTD		Work Order:	109092
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.154	.154	.149	.149	.149
AD	3.510	3.530		3.530	3.530	3.510	3.511	3.515
AE	1.633	1.673		1.667	1.668	1.657	1.655	1.657
AF	1.493	1.513		1.511	1.511	1.504	1.504	1.504
AG	0.040	0.060		.042	.041	.041	.051	.048
AH	0.188	0.193		.192	.192	.192	.172	.192
AI	0.140	0.160		.152	.151	.151	.150	.151
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.053	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.151	.150	.143	.150	.152
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.156	.157	.155	.154	.160
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		102.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.261	.261	.261	.261	.261
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.132	4.127	4.134	4.134	4.128
AV								
AW								
Accept/Reject								

Measured by:	RT D40 DADP.02	Date:	13-11-11
Audited by:	Emk	Date:	13-11-12 13/11/20
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

DART AEROSPACE LTD		Work Order: 109042
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6x	7x	8x	9x	10x
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.149	.150	.151	.145	.151
AD	3.510	3.530		3.508	3.5125	3.5115	3.5115	3.5115
AE	1.633	1.673		1.651	1.658	1.657	1.656	1.656
AF	1.493	1.513		1.508	1.508	1.508	1.509	1.509
AG	0.040	0.060		.047	.049	.055	.050	.051
AH	0.188	0.193		.192	.192	.192	.192	.192
AI	0.140	0.160		.150	.152	.154	.152	.151
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.150	.156	.153	.147	.152
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.154	.146	.145	.153	.151
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.261	.261	.261	.261	.261
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.124	4.130	4.129	4.135	4.128
AV								
AW								
Accept/Reject								

Measured by: LP D.P.	Date: 13-11-13
Audited by: CMZ	Date: 13/11/20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

DART AEROSPACE LTD		Work Order: 109042
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.152	.150	.148	.148	.156
AD	3.510	3.530		3.511	3.510	3.510	3.511	3.520
AE	1.633	1.673		1.654	1.654	1.655	1.654	1.660
AF	1.493	1.513		1.506	1.503	1.506	1.504	1.505
AG	0.040	0.060		.055	.052	.055	.053	.050
AH	0.188	0.193		.192	.192	.192	.192	.192
AI	0.140	0.160		.152	.153	.152	.152	.153
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.158	.158	.159	.156	.155
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.150	.151	.150	.150	.154
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.262	.262	.262	.262	.262
AT	0.053	0.073		.063	.063	.063	.067	.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: <i>[Signature]</i>	Date: 13-11-14
Audited by: <i>[Signature]</i>	Date: 13/11/20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	109042
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

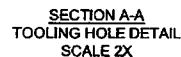
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	#17	#18	#19	#20
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.154	.154	.150	.152	.152
AD	3.510	3.530		3.518	3.519	3.518	3.522	3.521
AE	1.633	1.673		1.660	1.660	1.660	1.660	1.660
AF	1.493	1.513		1.508	1.508	1.508	1.503	1.509
AG	0.040	0.060		.047	.051	.047	.047	.053
AH	0.188	0.193		.192	.192	.192	.192	.192
AI	0.140	0.160		.153	.157	.153	.149	.148
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.155	.158	.154	.154	.151
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.157	.152	.156	.157	.158
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.262	.262	.262	.262	.262
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

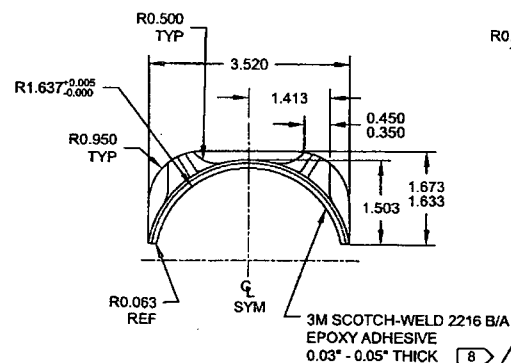
Measured by: <i>DA</i>	Date: 13-11-15
Audited by: <i>AM</i>	Date: 13/11/20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	<i>MS</i>

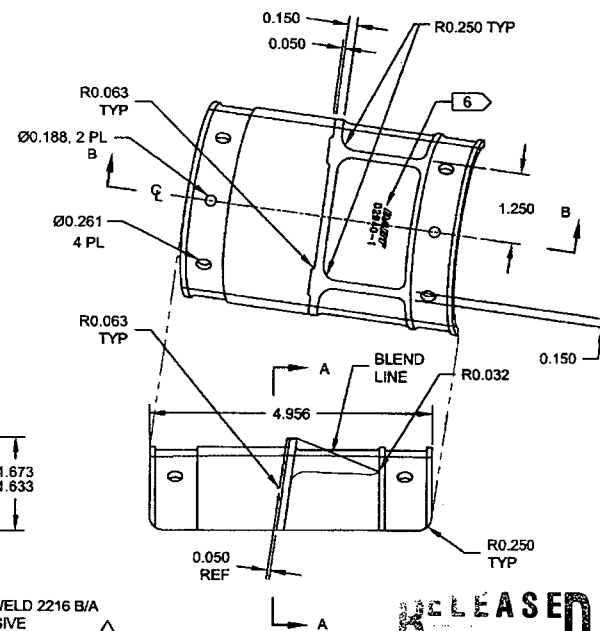


NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ± 0.010) UNLESS
OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART
NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.92 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK
(OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A
ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



D2940-1 SUPPORT



RELEASE
2011-07-28

C	RMV FINISH, ADD 3M 2216, ADD H925 MATL OPTION	CP	11.07.15
B	UPDATE PER NCR 642, PRIME INSIDE	PH	07.03.13
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>Q</i>	DAVID AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>Q</i>		
CHECKED	<i>AS</i>		
MFG. APPR.	<i>[Signature]</i>	DRAWING NO.	REV.
		D2940	SHEET 1 OF
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	Ø3.250 SUPPORT	NT
DATE	11.07.15	COPYRIGHT © 2001 BY DAVID AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DAVID AEROSPACE LTD	

109042 MJS
13-11-07